

इंटरनेट

मानक

Disclosure to Promote the Right To Information

Whereas the Parliament of India has set out to provide a practical regime of right to information for citizens to secure access to information under the control of public authorities, in order to promote transparency and accountability in the working of every public authority, and whereas the attached publication of the Bureau of Indian Standards is of particular interest to the public, particularly disadvantaged communities and those engaged in the pursuit of education and knowledge, the attached public safety standard is made available to promote the timely dissemination of this information in an accurate manner to the public.

“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 5926 (1970): Shell Reamers [PGD 32: Cutting tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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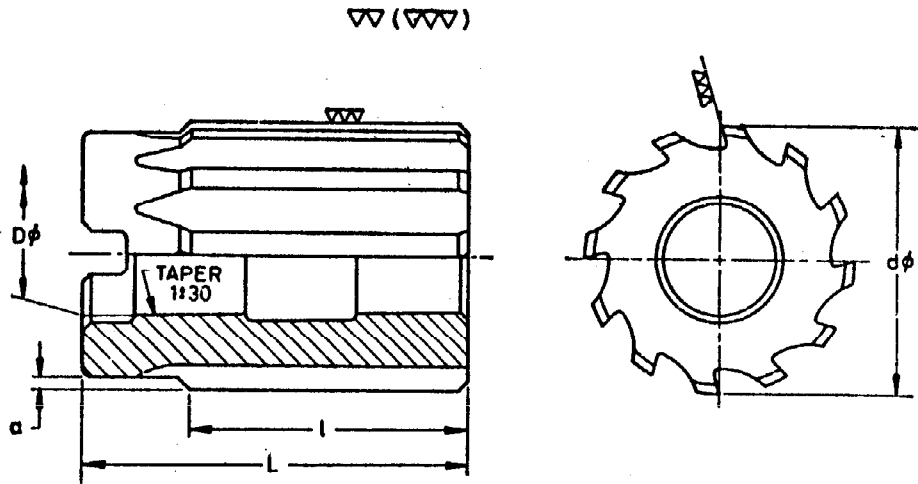


Indian Standard

SPECIFICATION FOR

SHELL REAMERS

1. Scope — Dimensions and requirements for shell reamers with taper bore and cross-slot-drive.
2. Dimensions



All dimensions in millimetres.

Range of Diameters <i>d</i> *		<i>D</i> †	<i>l</i>	<i>L</i>	<i>a</i> <i>Max</i>
Above	Up to and Including				
10·0	23·6	10	28	40	1·0
23·6	30·0	13	32	45	1·0
30·0	35·5	16	36	50	1·5
35·5	42·5	19	40	56	1·5
42·5	50·8	22	45	63	1·5
50·8	60·0	27	50	71	2·0
60·0	71·0	32	56	80	2·0
71·0	85·0	40	63	90	2·5
85·0	101·6	50	71	100	2·5

Note — The figure is indicative of dimensions only and does not specify design features.

*The tolerance on diameter *d* shall be m6.

†The bore diameter *D* is the same as nominal arbor diameter *D* according to IS : 5936-1970 ' Arbors with morse taper shanks for shell tools '.

3. Designation — A shell reamer with diameter *d* = 50 mm suitable for a hole with tolerance H8 and conforming to this standard and made from high speed steel (HS) shall be designated as:

Reamer 50 IS : 5926-HS

3.1 When the reamer is required for a hole with tolerance other than H8, the appropriate hole tolerance shall be included in the designation after size.

4. Tolerances on Flute Length and Overall Length

Length, mm		Tolerance mm
Over	Up to and including	
—	6	± 1.5
6	18	± 3.0
18	50	± 5.0
50	—	± 6.5

5. General Requirements

5.1 Nominal diameter d shall be chosen from the range of diameters d .

5.2 *Bevel Lead Angle* — 45°.

5.3 Back taper on diameter is recommended. The back taper if provided shall be within the limits of tolerance on the diameter.

5.4 Flutes unless specified otherwise: Parallel flutes for right-hand cutting.

5.5 Dimensions for tenons and cross-slots according to IS : 5568-1970 'Dimensions for tenons and cross-slots for tools with bore taper 1 : 30'.

5.6 Dimensions of arbors according to IS : 5936-1970 'Arbors with morse taper shanks for shell tools'.

5.7 Other requirements according to IS : 5443-1969 'Technical supply conditions for reamers'.

EXPLANATORY NOTE

In order to bring in line with the work done at ISO level, the Small Tools Sectional Committee, EDC 45, decided to revise IS : 1836-1961 'Specification for reamers' and split it up into a series of standards. This standard is one of the series and covers the dimensional requirements for shell reamers. The technical supply conditions for reamers and the dimensional requirements of various other reamers are covered in separate standards.

**AMENDMENT NO. 1 NOVEMBER 1990
TO
IS 5926:1970 SPECIFICATION FOR SHELL REAMERS**

(Page 2, clause 5.3) - Substitute the following for the existing clause:

"5.3 Back Taper - Back taper on the cutting diameter is recommended; when provided the amount of back taper shall be in accordance with IS 5443:1984 'Technical supply conditions for high speed steel reamers'."

(PED 10)

Reprography Unit, BIS, New Delhi, India

AMENDMENT NO. 2 DECEMBER 1996
TO
IS 5926 : 1970 SPECIFICATION
FOR SHELL REAMERS

(Page 1, clause 2, informal table, last line) — Substitute 'IS 5936 : 1981' for 'IS 5936 : 1970'.

(Page 1, clause 3, lines 2 and 3) — Substitute 'HSS' for 'HS'

(Page 2, clause 5.5) — Substitute 'IS 5568 : 1978' for 'IS 5568 : 1970'.

(Page 2, clause 5.6) — Substitute 'IS 5936:1981' for 'IS 5936:1970'.

(Page 2, clause 5.7) — Substitute 'IS 5443 : 1994' for 'IS 5443 : 1969'.

(PE 10)

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